

Work Order ID 50501

July 10, 2009 2:50:48 PM

Page 1

Item ID: D3964-3KIV

Revision ID: A-PROTO

Item Name: Light Cover w/ Ducts

Start Date: 07/13/2009 Start Qty: 1.00

Required Date: 07/17/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start _____
Stop _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3964	A-PROTO

100

0.00



HandThermo

Hand Finishing Thermoforming

Memo

1-Cut Sheet to required Blank size

0.00

BB 09/07/15 x1

M109703

110

0.00



Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA066 using tool DT9xxx
Dwg Rev: A
Folio Rev: A

0.00

BB 09/07/15 x1

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Item ID: D3964-3KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Light Cover w/ Ducts

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

BB 09/07/15 (X1)

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Db. 09/07/16 (X1)

140

0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

BB 09/07/16 X1

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Item ID: D3964-3KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Light Cover w/ Ducts

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control	Complete FAI document								
160	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									

BB 09/07/16 (X)

RH 09.07.20

FOR ENG'G TEST RH 09.07.20

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Item ID: D3964-3KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Light Cover w/ Ducts

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u 9.09.28
RD0303 u

Picklist Print

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Work Order ID: 50501

Parent Item: D3964-3KIVRevA-PROTO

Parent Item Name: Light Cover w/ Ducts

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased	No			100	sf	894.5038	1.0000			



6185 KYDEX .080"



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

894.5037653

109703

894.503765

BB

M109703

09/07/15

27" x 21" ÷ 5

W/O 50491

500

502

503

DART AEROSPACE LTD		Work Order: 50501
Description: LIGHT COVER W/ DOTS		Part Number: D3964-3K1V
Inspection Dwg: A	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 09/07/16

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.25	+0.10 -0.00	.262	✓			
6.5		6.4	✓			
4.2		4.125	✓			
2.0		2.03	✓			
.080		.048	✓			
0.230	MIN	0.220	✓			
φ0.125	φ +0.005 -0.001	φ0.127	✓			
0.75	±0.03	0.72	✓			
0.63		0.60	✓			
0.80		0.81	✓			
0.37		0.37				

Measured by: BB

Date: 09/07/16

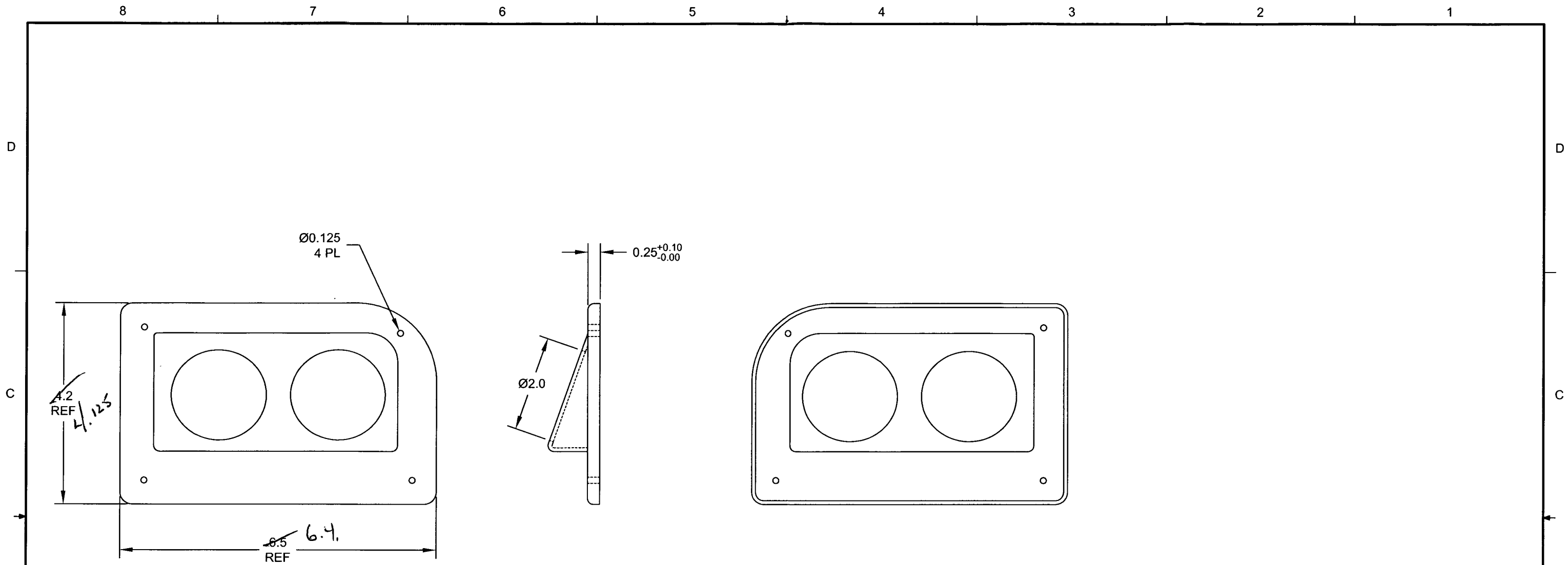
Audited by: RB

Date: 09.07.17

Prototype Approval: RB

Date: 09.02.17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



D3964-2 LIGHT COVER W/DUCTS

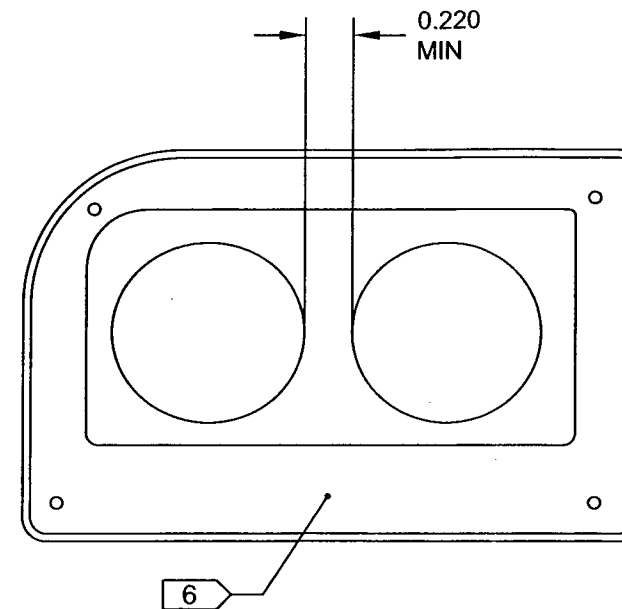
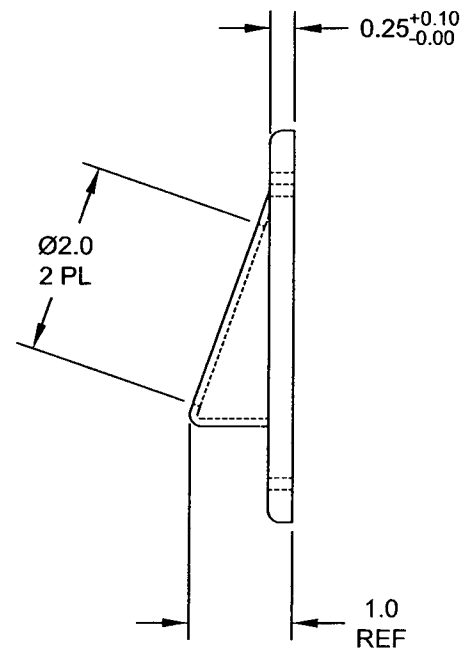
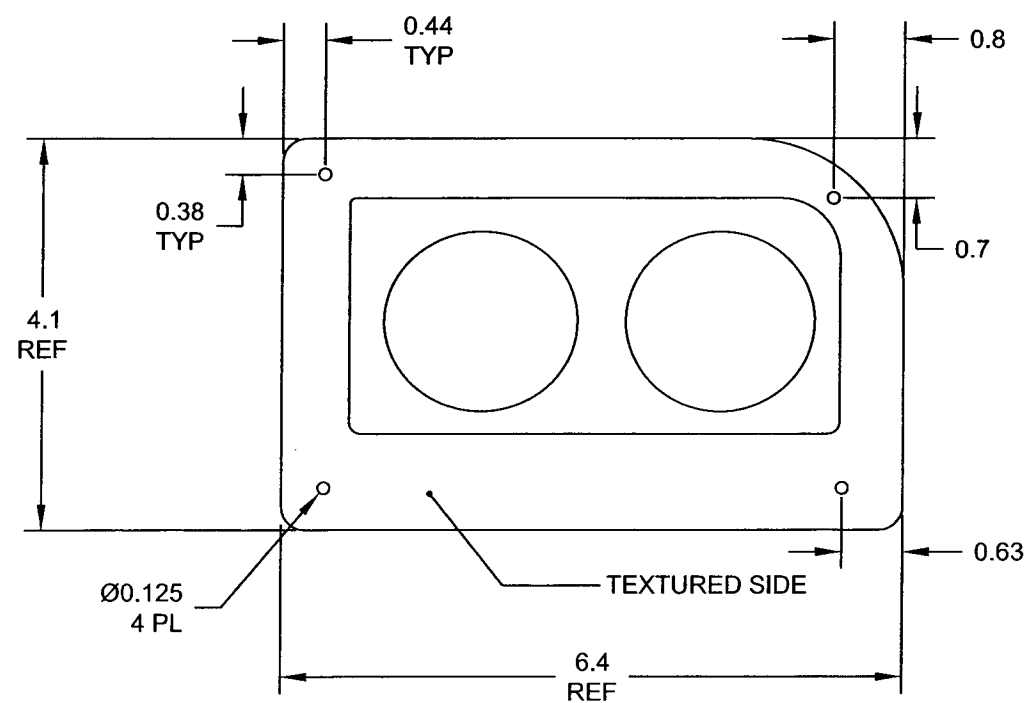
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
09.07.16 *RT*

50501

- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 0.08 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9358 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3964-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3964-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3964	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LIGHT COVER W/DUCTS (206 L3/L4)	NTS
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D3964-3 LIGHT COVER W/DUCTS

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.08 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9358 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.040" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3964-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3964-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PA		
CHECKED	PA	DRAWING NO.	REV. A
MFG. APPR.	PA	D3964	SHEET 2 OF 2
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	LIGHT COVER W/DUCTS (206 L3/L4)	NTS
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